

303 500

Work Order ID 70323

Thursday, June 02, 2011 2:47:39 PM



Page 1

Item ID: D3204-7

Revision ID:

Item Name: Bushing

Start Date: 6/8/2011 Start Qty: 20.00

Required Date: 6/17/2011 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

0.00

100



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

I-Turn D3204-7 bushing as per Folio FA355 and Dwg D3204L12-Deburr

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 70323

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Item ID: D3204-7

Accept



Setup

Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 6/8/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 41

0.00

11/7/16

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF
11-07-06

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 2:47:36 PM

Page 1

Work Order ID: 70323



Parent Item: D3204-7



Parent Item Name: Bushing

Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B (04.06.09) (Change Step 6; remove Steps 7 & 8) (KJ/RF)

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500 303 Round Bar 0.500"		Purchased	No			100	f	46.2000	0.0358	0.753684		SA	6/17/16

Location	Loc Qty	Loc Code
MAT028 117143	46.2 46.2	JKRF

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DART AEROSPACE LTD	Work Order:	140308
Description: Bushing	Part Number:	D3204-7
Inspection Dwg: D3204	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	1/17/06	Date:	1/10/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	✓ ✓

W/O:

WORK ORDER CHANGES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

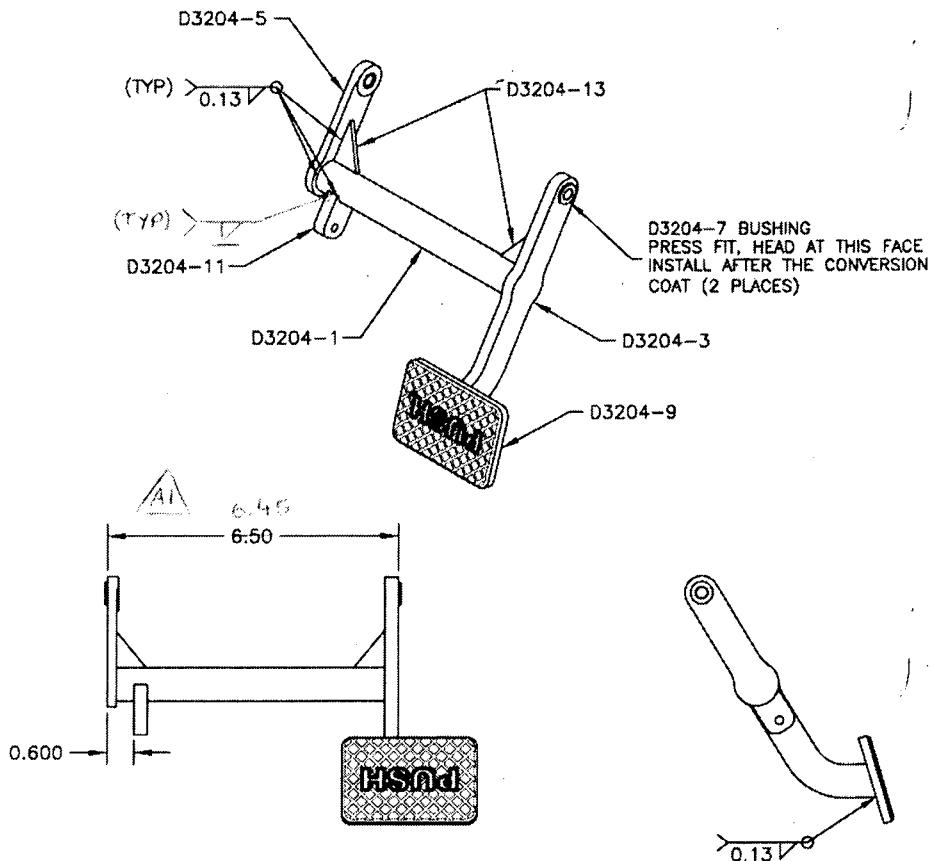
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED,	APPROVED	DRAWING NO.	REV. A
		D3204	SHEET 1 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS
A	04.01.27	NEW ISSUE	

AI ~~04.01.27~~ 05.07.15 6.45 was also



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

10328

W/O:

WORK ORDER CHANGES

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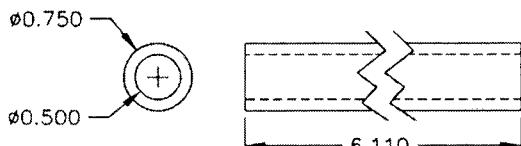
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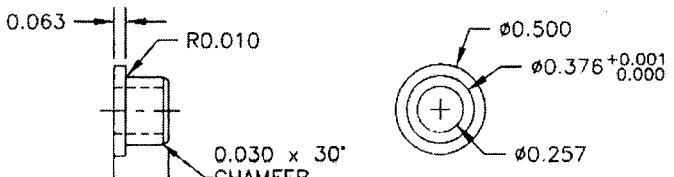


DESIGN R	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ✓	APPROVED ✓	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

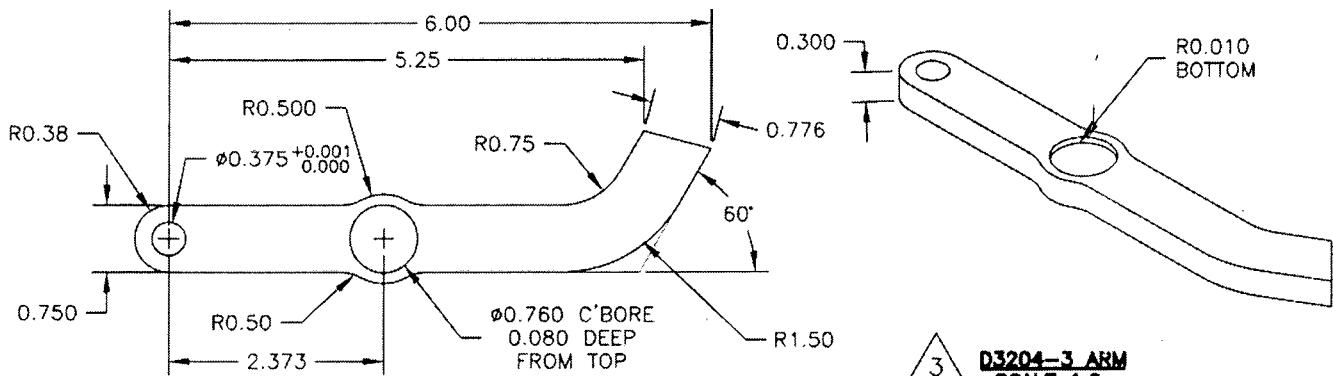
RELEASED
04.04.05 #



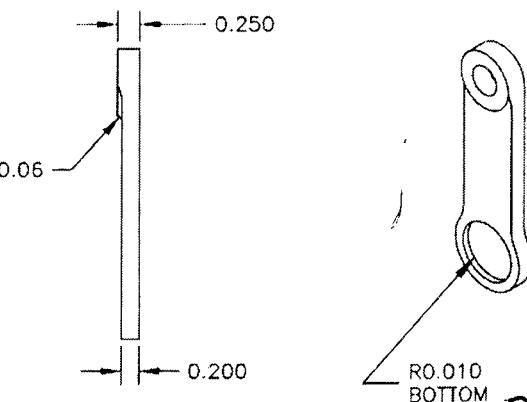
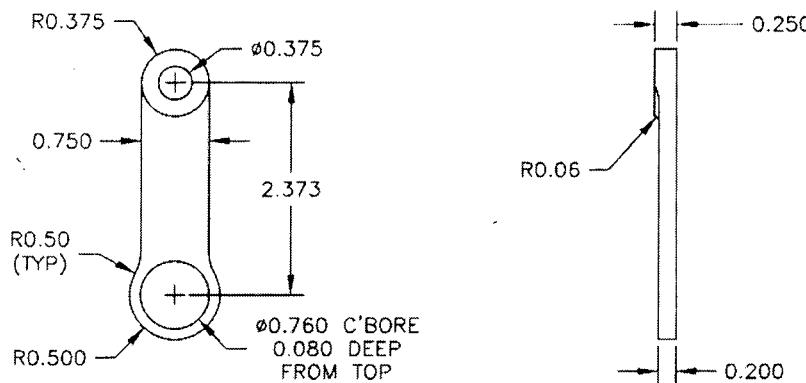
2 D3204-1 TUBE
SCALE 1:2



4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2

10328

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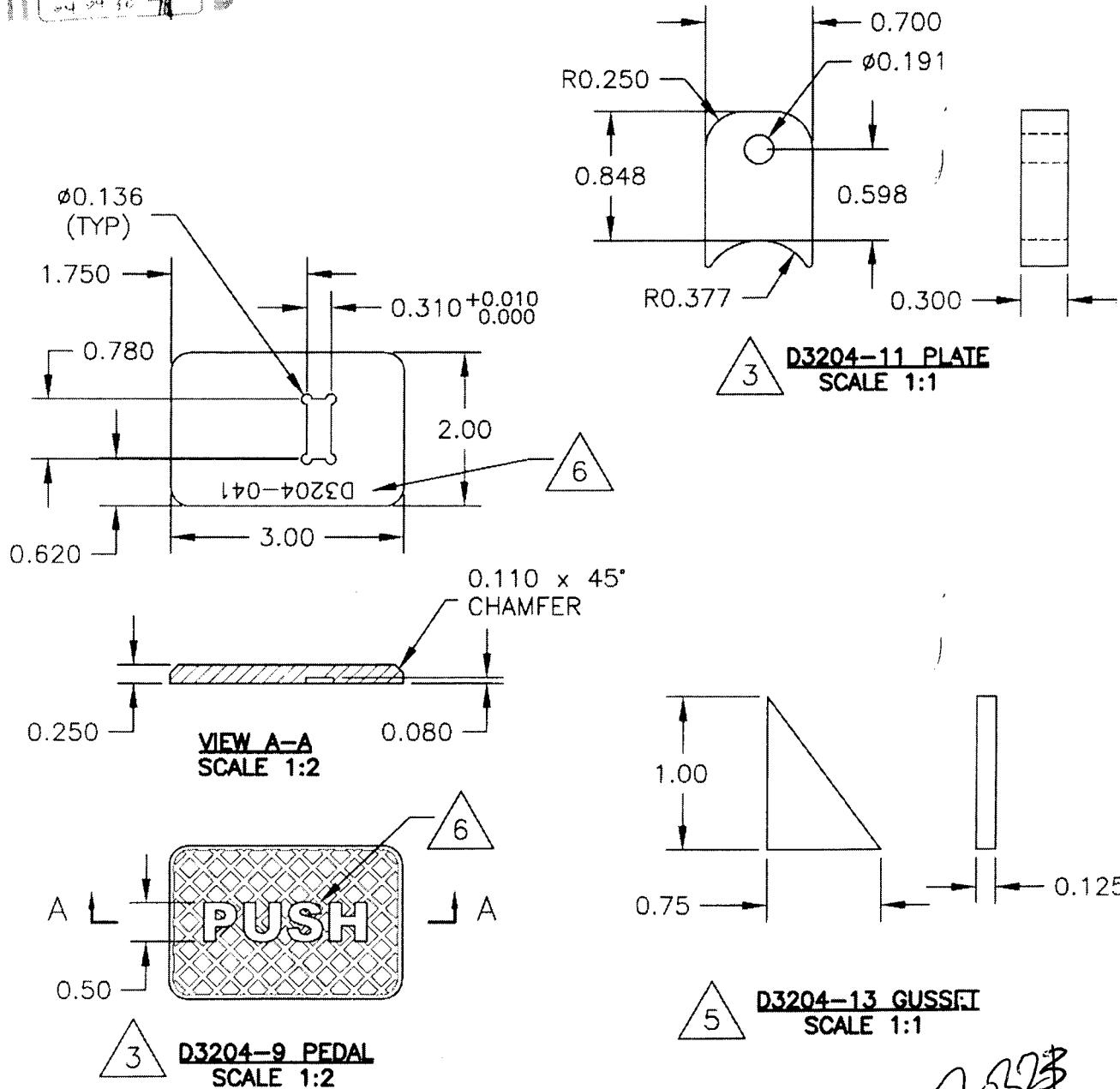
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DESIGN <i>PP</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>HF</i>	APPROVED <i>HF</i>	DRAWING NO. D3204 REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE SCALE RELEASE PEDAL ASSEMBLY NTS

RELEASED
04-04-30



W/O:

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